

Work Order ID 144838

April 26, 2016 9:15:46 AM

144838

Page 1

Item ID: D2944 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Mounting Plate
 Start Date: 4/28/2016 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 5/13/2016 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: SH Date: 20160426 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2944	Rev A

100	FLOW WATER JET	0.05							
100									
Waterjet	Memo	1.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2944 Dwg Rev: <u>1A</u> Prog Rev: <u>1A</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.20							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.40							
Quality Control									

DAS
38
9-89
APP 28 7016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

20

20

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

**Insp.
Stamp**

Identify as per dwg & Stock Location:

0.00

130

0.20

Packaging

Packaging

Memo

*** STOCK IN STEP CELL***
LOCATION WA003

140

QC21- Final Inspection - Work Order Release

0.00

140

2.00

QC

Quality Control

Memo

32

8-60

ADD 7 0 2018

ML5

MAY 02 2016

2m 16/04/29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

Picklist Print

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Work Order ID: 144838

144838

Parent Item: D2944

D2944

Parent Item Name: Step Mounting Plate

Start Date: 4/28/2016

Required Date: 5/13/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP B04.01.21Reformat; Added Step 6KJ/RF
IPP C 06.07.21 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.187X04.00 0		Purchased		No		100	f	42.6000	0.2458	5.174737			

M6061T6B0 187X04 000

6061-T6 Bar .187 x 4.00

26/04/27

Location	Loc Qty	Loc Code
MAT001	42.6	
m125590	5.5	
m128265	13.1	
m132835	4	
m133548	20	

M6061T6 S .188

Batch 129146 1.8

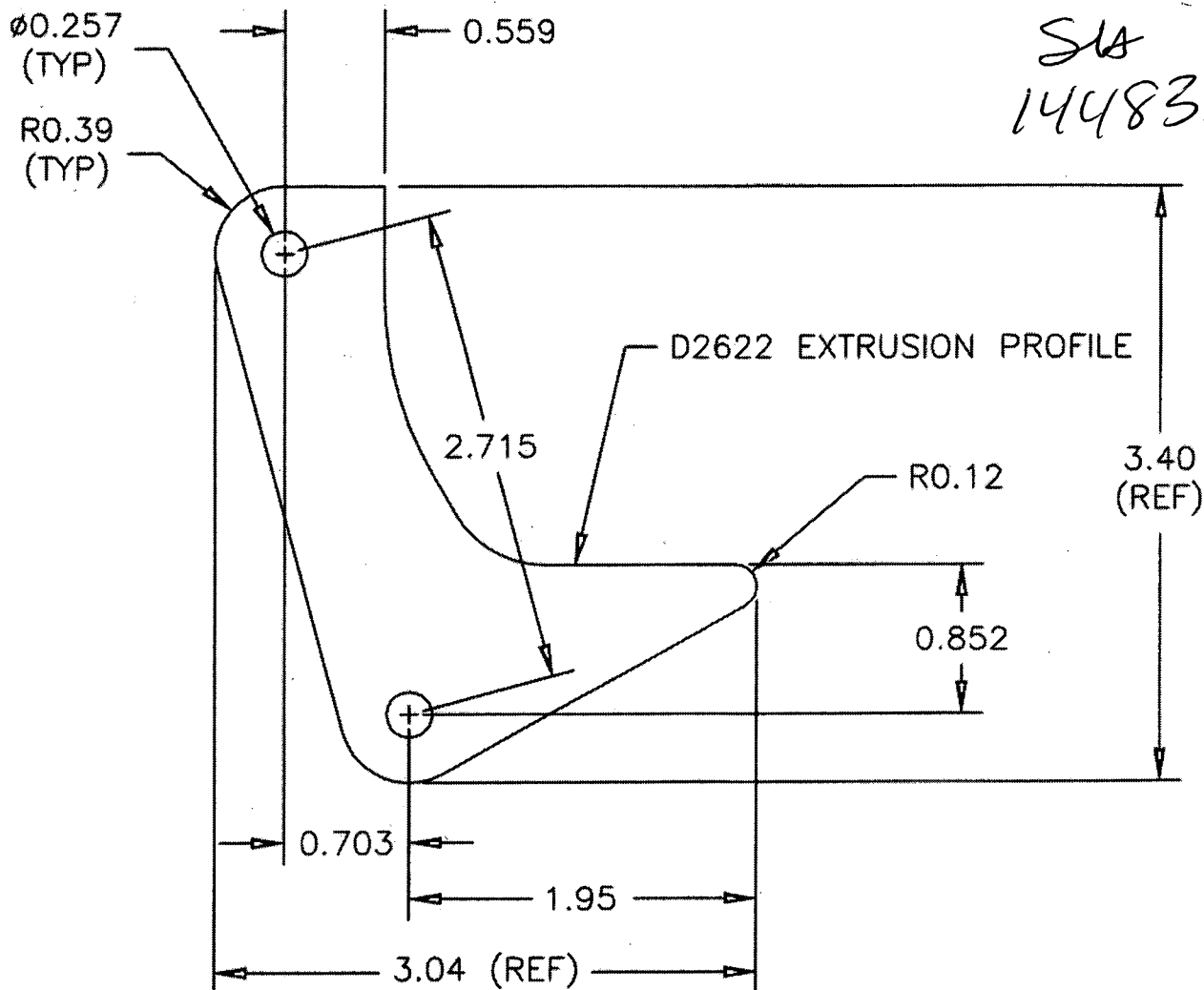


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2944	REV. A SHEET 1 OF 1
DATE 99.12.13		TITLE STEP MOUNTING PLATE	SCALE 1:1
A	99.12.13	NEW ISSUE	

RELEASED
99.12.21 DS

20160426

SLA
144838



MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK
BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

DART AEROSPACE LTD		Work Order: 144838
Description: Step Mounting Plate		Part Number: D2944
Inspection Dwg: D2944	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	Ø.258	/		V.D.02	
0.559	+/-0.010	.559	/			
3.04	+/-0.030	3.04	/			
1.95	+/-0.030	1.95	/			
0.852	+/-0.010	.852	/			
2.715	+/-0.010	2.711	/			
3.40	+/-0.030	3.40	/			

Measured by: <i>de</i> Date: 16/04/27		DAS Audited by: 38 9-89 Date: APR 28 2016		Prototype Approval: N/A Date: N/A	
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Rev	Date	Change	Revised by	Approved
A	03.11.27	New Issue	KJ/RF	
B	07.09.06	Dimensions added	KJ/JLM <i>KA</i>	<i>BE</i>